

Tuesday, 9/25/2007 10:13:35 AM
User: Kim Johnston

Process Sheet

split w/o
SB 07/10/03

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 34855
Estimate Number : 11174
P.O. Number : *N/A*
This Issue : 9/25/2007 S.O. No. : *N/A*
Prsht Rev. : NC
First Issue : *N/A* Type : SMALL /MED FAB
Previous Run : 32285

Drawing Name : REPLACEMENT WINDOW ASSEMBLY

Part Number : D3290041
Drawing Number : D3290 UNDER REVIEW
Project Number : N/A
Drawing Revision : *BC PER ECN# 799 DC*
Material : *N/A*
Due Date : 10/2/2007

Qty: *15* Um: Each

Written By : *DA 07.09.25*
Checked & Approved By : *DA 07.09.25*
Comment : Est. B 06.05.25 Added Step 11 KJ/JLM
Est. C 06.05.09 Ecn 798 EC
Est Rev:D Now on Waterjet 06-06-16 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 ~~M5052H32S040~~ *6061 TC .040* 5052-H32 .040 Sheet

Comment: Qty.: 3.9375 sf(s)/Unit Total: 15.7500 sf(s)

~~5052 H32 .040 Sheet~~

(M5052H32S040)

Batch: *M 102723 XB**HB 07-10-1**M 100742 X6**23.625*2.0 WATER JET *31.5000* FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3290

Dwg Rev: *B* *HB 07-10-1*Prog Rev: *B*2-Deburr if necessary *HB 07-10-1**(14)*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

*HB 07-10-1*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5 07/10/01 (14)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*(14)**BR 07-10-02*

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Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M105068



(14X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 07/10/02

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(14)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/10/03

8.0

D2126

Seal



Comment: Qty.: 6.5000 f(s)/Unit Total : 26.0000 f(s)
Locking Seal

Pick:

Qty Part Number Description

Batch

1 D2126-0780 Locking Seal

1332619

(2)

13P100

B

(14)

9.0

D32901

Window Frame



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)
Window Frame

Pick:

Qty Part Number

Description

Batch

1 D3290-1

Window Frame

34855

~~2683~~

SAD

07-10-03

2

10.0

D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Window

Pick:

Qty Part Number

Description

Batch

1 D3290-3

Window

1329568

B

7/10/03

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

SAD 07-10-03

PTD

(14)

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Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 7/10/03 (2)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

En 7/10/03 (2)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



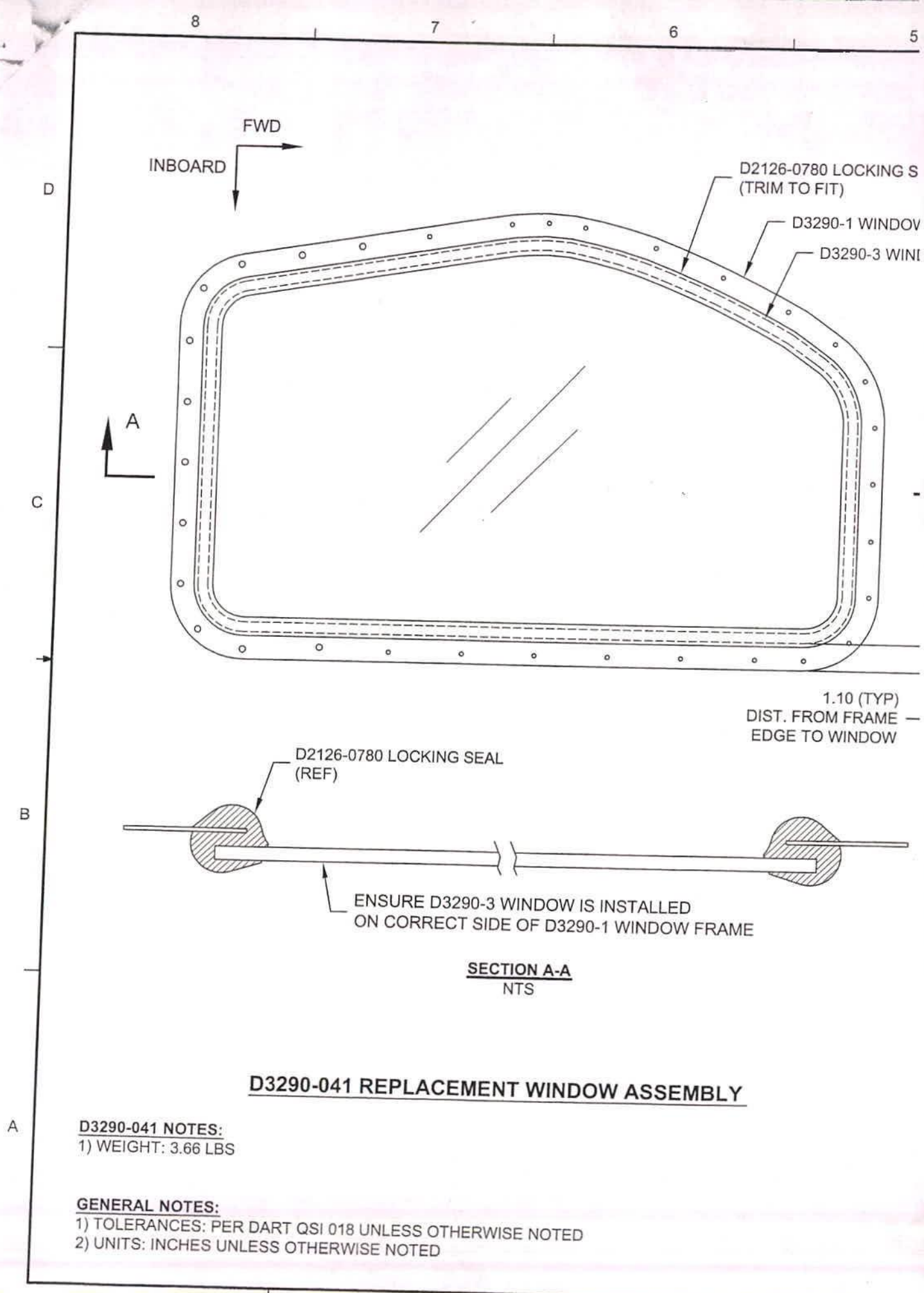
Comment: FINAL INSPECTION/W/O RELEASE

(2)
7/10/04

Job Completion



u 57/10/03



D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/03	11	split 20	SB	07/10/03	2		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• NOTE: Date & initial all entries